

Work Order ID 51472

August 25, 2009 1:02:13 PM

ASAD



Item ID: D3643-2

Accept



Setup Start



Revision ID: A

Stop



Item Name: Stiffener

Start Date: 8/25/09

Start Qty: 12.00



Cust Item ID:

Required Date: 8/31/09

Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

PL

Date: 09-8-25 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3643

Rev A

12

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3643 Dwg Rev: A Prog Rev: A 2-
Deburr if necessary

IB 9-8-17

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

IB 9-8-17

12

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

= 7 8 02/02/06

412

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 51472

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Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

Brake NC

NC BRAKE

Memo

Form as per Dwg D3643

0.00

0.00

SB 09/08/24 (12)
Deburr M.L 09/08/26 (12x)

140



Small Fab

Small Fab

Small Fab

Memo

C'sink as per Dwg D3643

0.00

0.00

SB 09/08/26 (12)

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

27 80208/26 (12) 4

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

Chemical Conversion Coat per QSI005 4.1

0.00

MD 09/08/27 (X12)

HandFinish

Memo

0.00

Hand Finishing

170

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

180

Identify as per dwg & Stock Location: 243

0.00

Packaging

Memo

0.00

Packaging

Packaging 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Tooling:

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Run Start



QC:

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Sequence ID/
Work Center ID

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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/08/28 J

PL 09-8-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

August 25, 2009 1:02:13 PM

Work Order ID: 51472

Parent Item: D3643-2RevA

Parent Item Name: Stiffener

Comments:



Start Date: 8/25/09

Required Date: 8/31/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	259.9566	1.8632			



2024-T3 .040 sheet

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	259.9565789	
110337	6.4	
111786	39.0665789	
112291	96	
112331	118.49	

112291

B 9-8-17

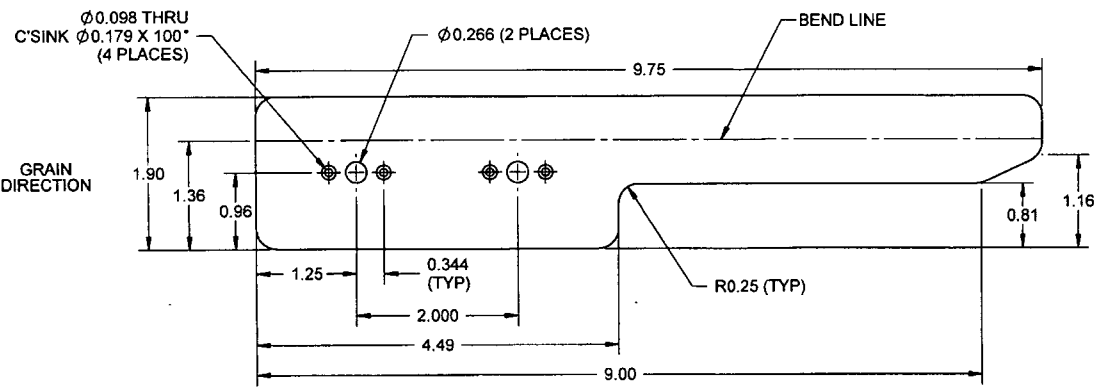
W/O:		WORK ORDER CHANGES					
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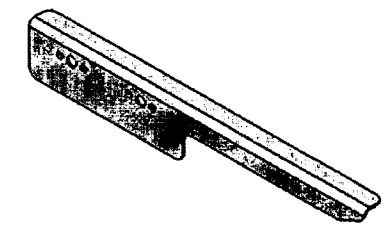
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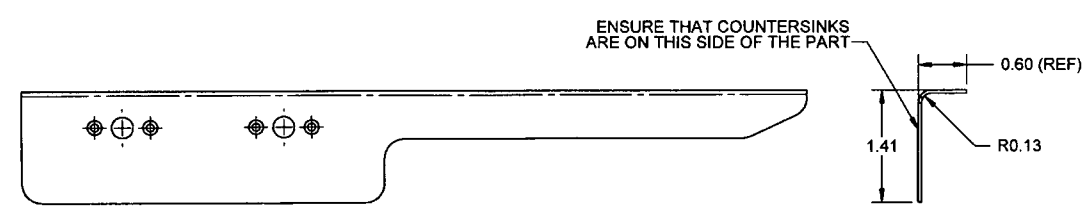
NOTE: Date & initial all entries



D3643-1F FLAT PATTERN
(D3643-2F OPPOSITE)



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK CENTER
NO. 51472 *PS*



D3643-1 STIFFENER (REPLACES GENEVA P/N G10610-2)
D3643-2 OPPOSITE (REPLACES GENEVA P/N G10610-1)

RELEASED
07.09.07

- NOTES:
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3643-1/-2" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: 0.06 lbs

A	NEW ISSUE; REPLACES G10610	LE	07.07.27
REV.	DESCRIPTION	BY	DATE
DESIGN	DTI		
DRAWN	CE		
CHECKED	BE		
MFG. APPR.	BE		
APPROVED	NO		
DE APPR.	SH		
DATE	07.07.27		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3643 TITLE STIFFENER REV. A SHEET 1 OF 1 SCALE 2:3 <small>COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			